

## SPECIFICATION

DEVICE FOR DISCHARGE ROD-LIKE PRODUCT WHOSE ONE END IS  
LARGER SIZED

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## TECHNICAL FIELD

[0001]

This invention relates to a device for arranging rod-like products in order one end of each of which is larger sized and discharging them, and particularly, to a discharge device optimal for arranging pipet tips in order and discharging them.

## BACKGROUND ART

[0002]

Pipet tips each in the shape of a rod-like product one end of which is larger sized are transported on a tray on which being longitudinally and laterally arranged and taking a vertically erected posture. They are provided to an automatic tester in a state of being accommodated in the tray. Since the tray remains behind after the pipet tips are used, the tray has to be discarded.

There has been a tremendously large quantity of pipet tips consumed in the entire country. Hence, trays have also been discarded in an extremely great quantity, having resulted in actual circumstances of requirement for high expenses in disposal. This harmful influence of the disposal can be eliminated by adoption of a scheme in which pipet tips are not accommodated in a tray while taking a specific posture, but pipet tips are transported, for example, in bags or boxes and then set in a tester. When a tray is adopted, however, pipet tips are arranged in specific positions while taking a specific posture, which can allow a discharge mechanism with a simple construction for pipet tips in an automatic tester to be attained. On the other hand, pipet tips transported in bags or boxes are not specified in posture and position prior to setting them into an automatic tester, leading to setting them therein in a non-controlled manner. Hence, the tester is required to take out each of pipet tips in an individually particular posture fed into the tester in a non-controlled manner.

[0003]

There has been developed a mechanism in which pipet tips each taking a random posture are taken out and arranged in a specific posture (see JP-A Nos. 2000-19182 and 2001-187629).

5 [0004]

A discharge device for pipet tips described in JP-A No. 2000-19182 is constructed so that pipet tips fed at random are taken out individually by lifting up a single pipet tip at a time with a conveyor having a belt in an almost vertical posture and the separated pipet tip is dropped down thus fed by the conveyor onto a slope. The slope is inclined at a downward gradient toward a slit and the pipet tip drops down into the slit. The slit is a clearance that disables the flange of a pipet tip to pass therethrough. Therefore, a pipet tip is discharged from the slit while taking a posture in which the flange of the pipet tip is caught by the slit. The discharge device is complex in structure and high in  
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15 manufacturing cost. An expensive discharge device can be employed as a device for feeding pipet tips fed at random into a tray. A complex, expensive mechanism is difficult to be adopted for a tester. This is because the number of testers are extremely more than the number of devices feeding pipet tips into trays. Therefore, a simple, inexpensive discharge device is required in order to  
20 omit a tray by installing a discharge device to a tester. Moreover, since, in this device, conventionally, a pipet tip is dropped down onto a slope, this device has a fault that a pipet tip receives a bad influence such as that the shock gives a damage to a pipet tip.

[0005]

25 A discharge device described in JP-A No. 2001-187629 is equipped with a rotary drum feeding pipet tips at random. The rotary drum has a scooping trough for pipet tips on the inner surface thereof. While the rotary drum is rotated, pipet tips are lifted up by the scooping trough and thereafter, dropped down from the scooping trough on slide rails. A pipet tip on the slide  
30 rails passes through a falling-down guide and then is dropped down at a determined position on the tray. The discharge device with this structure is also complex in structure and high in manufacturing cost. In addition, since a pipet tip is dropped down, there has been a fault that a pipet tip receives a

damage with ease because of the shock.

[0006]

The invention has been made in order to solve the faults that the conventional discharge devices have had and it is an important object of the invention to provide a device for discharge a rod-like product one end of which is larger sized, such as a pipet tip, fed at random, capable of arranging rod-like products in specific posture and discharge them therein with a extremely simple structure and a reduced manufacturing cost.

[0007]

It is another important object of the invention to provide a device for discharge a rod-like product one end of which is larger sized, capable of arranging rod-like products fed at random in order and discharge them with reduction in shock and damage to be imposed on the rod-like products.

## DISCLOSURE OF THE INVENTION

[0008]

The inventors have conducted serious studies in order to achieve the above objects, having resulted in completion of the invention. A discharge device set forth in claim 1 of the invention is directed to a device for discharge a rod-like product W one end of which is larger sized, including a hopper 10 not only swaying, but also having an opening portion 11, at the bottom surface thereof, extending in a direction of a rotation center axis of a swaying motion; a driving mechanism 20 swaying the hopper 10; and a bottom cover 30 closing the opening portion 11 of the swaying hopper 10 so that rod-like products W do not escape therefrom. The bottom cover 30 has the upper surface closing the opening portion 11 of the hopper 10 profiled so as to be in conformity with a locus on which the opening portion 11 of the swaying hopper 10 moves and a slit 31 extending in a direction perpendicular to a direction of the swaying motion so as to be open on the upper surface. The slit 31 has a width that does not allow the maximum outer size portion of a rod-like product W to pass therethrough, but lets almost all the rod-like product to pass therethrough. In the discharge device, the driving mechanism 20 sways the hopper 10 so that the opening portion 11 of the hopper 10 moves along the upper surface of the

bottom cover 30 to thereby guide rod-like products W accommodated in the hopper 10 into the slit 31 of the bottom cover 30 and to discharge the rod-like products W from the slit 31 being arranged in order therein.

[0009]

- 5           A discharge device set forth in claim 2 of the invention vibrates the bottom cover 30 to discharge the rod-like products W guided into the slit 31.

[0010]

- 10           In a discharge device set forth in claim 9 of the invention, rubber-like elastic bodies 14 are fixed at the opening portion 11 of the hopper 10 so as to be close to the bottom cover 30.

[0011]

- 15           In a discharge device set forth in claim 10, a width of the rubber-like elastic bodies 14 fixed at the opening portion 11 of the hopper 10 is defined to have a width in which the end edges thereof get close to the slit 31 when the hopper 10 is inclined. In a discharge device set forth in claim 11, inclination plates 15, which are replacements for the rubber-like elastic bodies, are connected to the opening portion 11 of the hopper 10. The inclination plates are connected so that the end edges thereof are close to the bottom cover 30. In a discharge device of claim 12, elastic bodies 16 are connected to the  
20           inclination plates 15 so that the end edges of the inclination plates 15 get close to the bottom cover 30 using the elastic bodies 16.

[0012]

- 25           A discharge device set forth in claim 13 of the invention is equipped with a removal arm 50 catching and pulling off a pipet tip, by the flange thereof, moved in a piled-up state, wherein rod-like products are pipet tips. A discharge device set forth in claim 14 is not only equipped with the removal arm 50, so as to be inclined relative to a fixing portion 35 not swaying together with the hopper 10, but also has an inclination mechanism 52 for inclining the removal arm 50 constituted of permanent magnets 53 fixed on the hopper 10 and the removal  
30           arm 50 at respective opposite portions thereof.

[0013]

          In a discharge device set forth in claim 15 of the invention, the bottom cover 30 is provided with an upward inclined slit 32 catching the flange of an

pipet tip piled up on a pipet tip moved in the slit 31 and raising the piled up pipet tip. The upward inclined slit 32 is not only inclined at an upward gradient in a moving direction of the pipet tips, but the fore end of the removal arm 50 is also provided to the upward inclined slit 32, thereby enabling the piled-up pipet tip  
5 moved along the upward inclined slit 32 to be removed.

[0014]

A taking device set forth in claim 16 has a clearance 33 through which the flange T of a rod-like product W at the lowest level passes between the fore end of the upward inclined slit 32 and the bottom cover 30 and the clearance 33  
10 is narrower than twice a thickness of the flange T of a rod-like product W.

[0015]

A discharge device of the invention is characterized in that rod-like products such as a pipet tip fed at random can be arranged in specific posture and taken out therein with an extremely simple structure and a mechanism  
15 capable of reducing a manufacturing cost. This is because the talking-out device sways the hopper and guides the rod-like products into the slit in the bottom cover provided at the opening portion to take out the rod-like products through the slit.

[0016]

20 A discharge device for a rod-like product of the invention with the above construction is further characterized in that rod-like products can be taken-out in arrangement with a specific posture with less of a shock and damage imposed on rod-like products.

## 25 BRIEF DESCRIPTION OF THE DRAWINGS

[0017]

Fig. 1 is a cross-sectional view of a discharge device for a rod-like product related to one embodiment of the invention,

Fig. 2 is longitudinal sectional view of the discharge device for a rod-like  
30 product shown in Fig. 1,

Fig. 3 is an enlarged sectional view showing another example slit,

Fig. 4 is a sectional view showing another example hopper,

Fig. 5 is an enlarged sectional view showing a state where rod-like

products with two flanges piled up at two levels are moved,

Fig. 6 is a perspective view showing the vicinity of an upward inclined slit of the discharge device for a rod-like product shown in Fig. 1, and

Fig. 7 is an enlarged plan view of fore end portions of a removal arm.

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## BEST MODE FOR CARRYING OUT THE INVENTION

[0018]

Description will be given of an embodiment of the invention based on the accompanying drawing. Examples shown below are, however, discharge devices in order to embody a technical concept of the invention presented by way of illustration and the invention does not specify a discharge device thereof to be any of the devices described below.

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[0019]

The specification attaches reference numbers indicating members shown in the examples to corresponding members shown in [claims] and [Disclosure of the Invention] for understanding of metes and bounds of claims. It should be understood, however, that the members shown in claims are absolutely not to be specified to the members in the examples.

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[0020]

Detailed description will be given of a discharge device for a pipet tip used as a rod-like product one end of which is larger sized as an example of the invention. A discharge device of the invention can also arrange rod-like products in order one end of which is larger sized other than a pipet tip.

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[0021]

A discharge device shown in Figs. 1 and 2 includes: a hopper 10 having an opening portion 11 extending in a direction of a swaying rotation center axis at the bottom surface thereof; a driving mechanism 20 swaying the hopper 10; a bottom cover 30 closing the opening portion 11 of the swaying hopper 10; a transport mechanism 40 transporting rod-like products S guided into a slit 31 of the bottom cover 30; and a removal arm 50 removing a rod-like products W in a piled-up state guided into the slit 31.

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[0022]

The hopper 10 has a supply port 12 through which rod-like products W

is formed at the top thereof and the opening portion 11 closed by the bottom cover 30 at the bottom surface thereof. The hopper 10 of Fig. 1 has the opening portion 11 in the middle of a flat bottom plate 13. The hopper 10 having the flat bottom plate 13 can guide rod-like products W into the slit 13 while preventing bridging of the products W at the slit 31. The bottom plate can also be inclined toward the opening portion. The hopper 10 shown in the figure has a width of the opening portion 11 narrower than that of whole the hopper 10. The hopper 10 can accommodate a great quantity of rod-like products W and guide them into the slit 31 of the bottom cover 30. The hopper, however, can also have an opening portion extending all over the bottom. A width of the opening portion 11 provided to the hopper 10 is set so that a side edge of the opening portion 11 is in the vicinity of the slit 31 of the bottom cover 30 but not close the slit 31 when the hopper 10 takes the most inclined posture. Therefore, the width adopts an optimal value taking into consideration the maximum inclination angle to which the hopper 10 sways and a diameter of the bottom cover 30.

[0023]

The maximum inclination angle of swaying hopper 10 is preferably about 30 degrees. The hopper, however, can also sway in the range of from 5 to 60 degrees and more preferably in the range of from 10 to 45 degrees as a maximum inclination angle. A sway cycle of the hopper 10 is preferably about 3 sec. The sway cycle, however, is also preferably in the range of 0.5 to 10 sec and more preferably in the range of from 1 to 5 sec. If a cycle of swaying the hopper 10 is increased, rod-like products W move more slowly in the hopper 10; therefore, damage on a rod-like product can be significantly reduced. If a cycle of the hopper 10 is excessively longer, it takes a longer time to guide a rod-like product W into the slit 31. Therefore, a cycle of swaying the hopper 10 is set to an optimal value taking into consideration a time to discharge a rod-like product W.

[0024]

The rod-like products W are guided into the slit 31 toward a direction of the slit 31 formed in the bottom cover 30 in the hopper 10. Since the maximum outer size is larger than a width of the slit 31, the maximum outer size portion

(the flange in a case of a pipet tip) gets caught by the slit 31 and a rod-like product W is fed taking a vertical posture therein. A slit 331 is, as shown in Fig. 3, in the shape that a width is gradually narrower downward and while the maximum outer size portion of a rod-like product W cannot pass therethrough, almost all the rod-like product W can pass therethrough. In this figure, 330 indicates a bottom plate.

[0025]

A length of the hopper 10 is more than that of a rod-like product W in order to be able to direct a rod-like product W toward a direction of the slit 31.

10 The hopper 10 is, so as to be swivable, connected to the bottom cover 30 or a frame 60 at one side or both sides thereof. Since the hopper, however, can also sway while being placed on the bottom cover, it is not necessarily required that the hopper 10 is connected to the bottom cover or the frame. Instead, the hopper can be swayed while being supported by a driving mechanism.

15 [0026]

The opening portion 11 of the hopper 10 is closed by the bottom cover 30 in an inclined state of the hopper 10. In the hopper 10, rubber-like elastic bodies 14 are fixed at the opening portion 11 of the hopper 10 so as to be close to the bottom cover 30. Not only can the hopper 10 be inclined so that the end edge of the opening portion 11 get close to the bottom cover 30 without a clearance, but the opening portion can also slide smoothly on the surface of the bottom cover 30 with less of wear. The rubber-like elastic bodies 14 are preferably fixed so as to be exchangeable. The rubber-like elastic bodies 14 can prevent a clearance between the opening portion 11 and the bottom cover 30 from being generated by exchanging the rubber-like elastic bodies 14 if worn.

[0027]

30 The bottom cover 30 closes the opening portion 11 so that rod-like products W do not escape from the opening portion 11 of the swaying hopper 10. Since the hopper 10 sways, a profile of the upper surface of the bottom cover 30 is in conformity with a locus on which the opening portion 11 of the swaying hopper 10 moves and thereby, rod-like products W, even if the hopper 10 sways, do not escape between the opening portion 11 and the bottom cover



30. Since the discharge device of the figure sways the hopper 10 along a locus of a circle arc, a profile of the upper surface of the bottom cover 30 is shaped in conformity with an circular arc. The bottom cover can also take a profile along an ellipse on the upper surface thereof to close the opening portion  
5 of the swaying hopper. A discharge device with the bottom cover 30 having a profile of the upper surface in conformity with a circle or an ellipse can move smoothly on the opening portion 11 of the hopper 10. Especially, the hopper 10 having the opening portion 11 attached with the rubber-like elastic bodies 14 can move the rubber-like elastic bodies 14 smoothly on the upper surface of the  
10 bottom cover 30 by sliding thereon. The bottom cover can also take a profile of the upper surface in conformity with a polygon so that the opening portion 11 of the swaying hopper is closed without rod-like products being escaped from the opening portion 11. The bottom cover with the upper surface having a profile in conformity with a polygon changes a width of a clearance between the  
15 opening portion and the bottom cover while the hopper sways. Only if the maximum clearance between the opening and the bottom cover is reduced to a width at which no escape of rod-like products occurs, the hopper can sway so that no rod-like product does not escape from a clearance. In addition, a construction is also possible that rubber-like elastic bodies at the opening of the  
20 hopper are fixed and the rubber-like elastic bodies are deformed to thereby close a clearance between the opening portion and the bottom cover.

[0028]

Narrow, long rod-like products are, in a case, brought into a state of being gotten caught by one another in the vicinity of the slit, that is, a jamming  
25 state. Jamming of rod-like products can be eliminated by increasing a width of plate-like rubber-like elastic bodies. Rubber-like elastic bodies realizing no jamming have a width at which the end edge of the rubber-like elastic bodies get close to the slit when the hopper is inclined at the maximum inclination angle. The end edges of the rubber-like elastic bodies move as far as points in  
30 the vicinity of the slit each time the hopper is inclined. The rubber-like elastic bodies moving as far as points in the vicinity of the slit move rod-like products in a state of being gotten caught by one another with the end edges thereof to eliminates the jamming. Rubber-like elastic bodies realizing no jamming locate

the end edges thereof in the inside of the slit, at the side edges thereof or outside thereof when the hopper is in the maximum inclination state of being mostly inclined. Rubber-like elastic bodies the end edges of which are moved in the inside of the slit or outside thereof when the hopper is in the maximum inclination state pushes the flanges of rod-like products guided in a posture vertical relative to the slit. Therefore, the rubber-like elastic bodies push the flanges of the rod-like products guided into the slit and elastically deforms in itself. Rubber-like elastic bodies with the structure can effectively eliminate jamming of rod-like products in the vicinity of the slit. Rubber-like elastic bodies the end edges of which are located outside of the slit when the hopper is at the maximum inclination position do not push the flanges of rod-like products guided into the slit. Hence, the rubber-like elastic bodies do not push the flanges of rod-like products normally guided into the slit and move only rod-like products in a jamming state in the vicinity of the slit to eliminate jamming. Hence, elastic bodies with the structure are characterized in that rod-like products guided into the slit can be smoothly moved. Since the end edges of rubber-like elastic bodies located outside of the slit when the hopper is in the maximum inclination state also have an opportunity of lightly pushing the flanges of rod-like products guided into the slit, the rubber-like elastic bodies deform in itself by pushing the flanges thereof.

[0029]

A hopper, as shown in Fig. 4, can also be connected to inclination plates 415 instead of rubber-like elastic bodies. The inclination plates 415 are connected to an opening portion 411 of the hopper 410 so as to be able to be inclined. The inclination plates 415 cause the end edges thereof to be close to a bottom cover 430 to seal the hopper 410 so that rod-like products do not escape from the swaying hopper 410. The inclination plate 415 forces the fore end thereof to get close to the bottom cover 430 by the weight thereof. Elastic bodies 416 are, as shown in the figure, connected to the inclination plates 415 and the end edges of the inclination plates 415 can also be caused to get close to the bottom cover 430 by the elastic bodies 416.

[0030]

The bottom cover 30 has the slit 31 extending in a direction

perpendicular to a direction of a swaying motion of the hopper 10. The slit 31 is provided so as to be open on the upper surface of the bottom cover 30. The slit 31 has a width that does not pass the maximum outer size portion of a rod-like product W but passes almost all the rod-like piece W, which is the other part than the maximum outer size portion. This is because a rod-like product W is put into the slit 31 and moved along the slit 31 in a vertical posture while the flange thereof, which is the maximum outer size portion, is caught by the upper surface of the slit 31 and discharged. The slit 31 extends as far as the end portions of the bottom cover 30. This is because a rod-like product W guided into an end portion is discharged to the outside of the bottom cover 30. Rod-like products W are discharged through the slit 31 in a vertical posture. Therefore, the slit 31 is formed in the bottom cover 30 so as to be opened in a vertical direction. Since the slit can also discharge rod-like products in a slightly inclined posture, a vertical posture is not necessarily required and instead an inclined posture can also be adopted. Pipet tips, which are rod-like products W, each have a flange provided as the maximum outer size portion. Therefore, the slit 31 has a width such that while a flange cannot pass through the slit 31, the other portion than the flange can pass therethrough. Rod-like products moved into the slit are not necessarily required to have a shape with a flange and, for example, it can also have one end thereof as the maximum outer size portion in the shape of a cone or a pyramid.

[0031]

The driving mechanism 20 sways the hopper 10. The driving mechanism 20 in the figure includes: a crank mechanism 22 rotated by a motor 21; and a connecting rod 24 connected to a crank arm 23 of the crank mechanism 22. The lower end of the connecting rod 24 is connected to the crank arm 23, while the upper end thereof is connected to one side of the hopper 10 through respective spherical joints 25. When the motor 21 rotates the crank arm 23, the connecting rod 24 reciprocates to sway the hopper 10. The driving mechanism 20 can sway the hopper 10 in a simple mechanism. A discharge device of the invention does not specifically limit a driving mechanism swaying the hopper to the mechanism shown in the figure and any of all mechanisms capable of swaying the hopper; for example a shrinkable

cylinder can be connected to the hopper to sway the hopper by stretching or shrinking the cylinder.

[0032]

5 The transport mechanism 40 discharges rod-like products W guided into the slit 31 of the bottom cover 30 along the slit 31. The transport mechanism 40 in the figure is a vibrator vibrating the bottom cover 30. The vibrator vibrates the bottom cover 30 so as to move rod-like products W along the slit 31. The vibrator can move rod-like products W along the slit 31 in an extremely simple structure. The transport mechanism is not specifically limited to a mechanism vibrating the bottom cover. Any of mechanisms capable of  
10 discharging rod-like products in the slit: for example, a structure jetting air to rod-like products in the slit to thereby move them, a structure in which the bottom cover is inclined toward a moving direction of rod-like products, a structure having a conveyor on inner faces of the slit, or the like can be used.

15 [0033]

Rod-like products W such as pipet tips each having a cavity inside thereof are, in some cases, piled up at plural levels. This is because a rod-like product W is inserted into the cavity inside another rod-like products W and thereby piling up occurs. In order to discharge rod-like products W through the  
20 slit 31 by separating the rod-like products W into a single independent one, the discharge device in the figure is equipped with: a removal arm 50 removing a rod-like product moved in a piled-up state; and an upward inclined slit 32.

[0034]

25 The upward inclined slit 32 allows a rod-like product W at the lowest level moved along the slit 31 to pass thereunder without raising the rod-like product W at the lowest level but raises a rod-like product W moved in a piled up state relative to the rod-like product W at the lowest level. The maximum outer size portion of the rod-like products W piled up on the rod-like product W at the lowest level moves through a position higher than the maximum outer size portion of the rod-like product W at the lowest level. The upward inclined  
30 slit 32 has a clearance 33 between the fore end thereof and the bottom cover 30, through which the maximum outer size portion of the rod-like product W at the lowest level passes. The clearance 33 is a clearance through which only

the maximum outer size portion of the rod-like product W at the lowest level can pass. The clearance 33 is narrower than twice a thickness of the flange T of a rod-like product W. The upward inclined slit 32 with a clearance 33 having this width can, as shown in Fig. 5, prevent a rod-like product W at the lowest level having only the flange T of another rod-like product W, without being inserted, piled up on the flange of the rod-like product W of interest from passing therethrough. This is because the clearance 33 does not allow a flange T piled up on the other to pass therethrough. The maximum outer size portion of a rod-like product W moved in a state of being piled up on a rod-like product W at the lowest level is gradually raised along the upward inclined slit 32 as it moves. Hence, the fore end of the upward inclined slit 32 is located lower than the maximum outer size portion of a rod-like product W moved in a state of being piled up on a rod-like product W at the lowest level. The upward inclined slit 32 has a width narrower than the maximum outer size portion of a rod-like product W so as to be able to catch and raise the maximum outer size portion of the rod-like product W, wherein the width is able to pass almost all of the other portion than the maximum outer size portion therethrough. The upward inclined slit 32 is inclined at an upward gradient in a moving direction of a rod-like product W.

[0035]

Fig. 6 is a perspective view showing the vicinity of the upward inclined slit 32 of the discharge device. In the discharge device of the figure, conical covers 34 are fixed on both sides of the upward inclined slit 32. The opening portion 11 of the hopper 10 is gradually larger in width toward one end thereof so as to pass through the conical covers 34. A discharge device having the conical covers 34 can eliminate jamming of rod-like products W between the upward inclined slit 32 and the hopper 10.

[0036]

The upward inclined slit 32 is equipped with the fore end of a removal arm 50 at a position part way along. The removal arm 50 lifts up a rod-like product W moved along the upward inclined slit 32 to remove the lifted-up rod-like product W from a rod-like product at the lowest level. That is, the removal arm 50 pulls off the rod-like product W from the rod-like product W at

the lowest level by catching the flange, which is the maximum outer portion of a pipet tip as a rod-like product W. The discharge device having the upward inclined slit 32 and the removal arm 50 discharges only the rod-like product W at the lowest level already free from a piled-up state. A rod-like product W  
5 piled up on the other can also be removed only with the removal arm without using the upward inclined slit. The removal arm locates the fore ends thereof at its lowest position so as to be lower than the flange, which is the maximum outer portion of the rod-like product moved in a state of being piled up on the rod-like product at the lowest level.

10 [0037]

The removal arm 50 is installed so as to be inclined relative to a fixed portion 35 not swaying together with the hopper 10. The removal arm 50 in the figure is connected to the bottom cover 30 as a fixed portion so as to be inclined relative thereto. In order to fix the removal arm 50, a support pole 36  
15 extending vertically is fixed to the bottom cover 30 and the removal arm 50 is connected to the support pole 36 so as to be inclinable in a vertical plane. The removal arm 50 is connected to the support pole 36 with a rotary shaft 51 interposed therebetween so as to be inclinable in the vertical plane including the slit 31. The removal arm 50 is inclined by an inclination mechanism 52 to pull  
20 off a rod-like product W moved in a piled-up state.

[0038]

The inclination mechanism 52 in the figure is permanent magnets 53 fixed to the respective opposite portions of the hopper 10 and the removal arm 50. A driving arm 54 extends upward from a portion of the removal arm 50  
25 which is connected to the support pole 36 and a first permanent magnet 53A is fixed to the driving arm 54. In addition, a second permanent magnet 53B is fixed at a position opposite to the first permanent magnet 53A on the hopper 10 while the hopper 10 sways. The inclination mechanism 52, while the hopper 10 sways, repeats motions in which one of second permanent magnets 53B  
30 gets close to the first permanent magnet 53A or gets far away from it. The first permanent magnet 53A and a second permanent magnet 53B are facing each other, with an N pole of the former and an S pole of the latter at respective opposite faces, or vice versa. The second permanent magnets 53B are, as

shown in Fig. 1, dotted on a locus in which the first permanent magnet 53A moves. Hence, when a second permanent magnet 53B gets close to the first permanent magnet 53A in a swaying motion of the hopper 10, the fore end of the removal arm 50 is inclined so as to lift up the fore end thereof. When a  
5 second permanent magnet 53B gets far away from the first permanent magnet 53A in a swaying motion of the hopper 10, the fore end of the removal arm 50 is inclined so as to move down the fore end thereof by the weight of itself. In addition, in a case where, though not shown, the second permanent magnets each having the same polarity as the first permanent magnet on respective  
10 opposite faces are arranged at positions on a line opposite a locus of the motion of the first permanent magnet, the removal arm can be quickly inclined so as to move down the fore end thereof by a repelling force from a second permanent magnet. The inclination mechanism moves upward the fore end when the first permanent magnet passes by a second permanent magnet with a polarity  
15 different from that of the first permanent magnet, while moving downward the fore end when the first permanent magnet passes by a second permanent magnet with the same polarity as the first permanent magnet. That is, the removal arm can be quickly inclined by a magnetically attracting force and a magnetically repelling force between permanent magnets. The inclination  
20 mechanism to incline the removal arm by a magnetic force between permanent magnets can incline the removal arm with an extremely simple structure.  
[0039]

The removal arm 50 to be inclined by a magnetic force can be inclined so as to move upward the fore end thereof to catch a rod-like product W piled  
25 up on a rod-like product W at the lowest level and to pull off the rod-like product W in a piled up state from the other. The removal arm 50, as shown in Fig. 7, has a pair of catching tips 50A at the fore end thereof so as to be able to catch a rod-like product W moved in a piled-up state by inclining itself to thereby pull off the rod-like product W. A separation width of the catching pieces 50A is  
30 narrower than the maximum outer size portion of a rod-like product W, while being almost equal to the width of the upward inclined slit 32 at which almost all the other portion than the maximum outer size portion can pass through.  
[0040]

The removal arm 50 at the lowest position is located inside of the upward inclined slit 32, that is, lower than the upward inclined slit 32. The removal arm 50 moves upward so as to be able to catch a rod-like product W moved in the upward inclined slit 32 and to thereby remove the rod-like product W and thereby, removes a rod-like product W from a rod-like product W at the lowest level. Hence, the fore end of the removal arm 50 does not catch the rod-like product W at the lowest level moved in the slit 31 but is located at a position at which the fore end thereof catches a rod-like product W moved in a piled-up state on a rod-like product W at the lowest level.

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#### INDUSTRIAL APPLICABILITY

[0041]

A discharge device of the invention can feed rod-like products each having a flange at one end such as a pipet tip used in an analysis on blood, one end of which is larger sized in random posture without being arranged in a tray or the like in order, and can take out the rod-like products in arrangement in order.

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